

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005270**Date Inspected:** 09-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Jia, Mr. Lu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Paul Dawson arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay 7

This QA Inspector observed ZPMC welders Mr. Sun Tiyu, stencil 054459, Mr. Liu Zihong, stencil 062447, and Mr. Sishu Liang, stencil 048801, using an overhead gantry to perform Flux Core Arc Welding (FCAW) of stiffener to side plate welds designated as SP625-001. This FCAW appears to be progressing in compliance with project specifications.

This QA Inspector performed random final visual and ultrasonic (UT) inspections of approximately 10% length of OBG side plate weld SP586-001-086. This weld has previously been tested and accepted by ZPMC Quality Control personnel. The QA Inspector observed the weld that was ultrasonically inspected by this QA Inspector appears to comply with AWS D1.5 UT requirements. This weld is listed on ZPMC Notification of Witness Inspection document 001819. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

This QA Inspector observed ZPMC welder Mr. Wang Hong Bo, stencil 203206 is using shielded metal arc welding procedure WPS-B-P-2112-FCM to make fillet tack welds on OBG side plate stiffener welds

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SP692-001-001. Prior to welding the QA Inspector observed the base material was preheated using a torch. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

OBG Bay 6

This QA Inspector performed random final visual and ultrasonic (UT) inspections of approximately 25% length of tower diaphragm welds ESD1-DP5A3-15-2 and ESD1-DP5A3-15-8. These welds have previously been tested and accepted by ZPMC Quality Control personnel. The QA Inspector observed the welds that were ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. These welds are listed on ZPMC Notification of Witness Inspection document 001816. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

This QA Inspector performed random final visual and ultrasonic (UT) inspections of 100% length of tower diaphragm weld ESD1-DP5A3-11-7. The QA Inspector observed the weld that was ultrasonically inspected by this QA Inspector appears to comply with AWS D1.5 UT requirements. The weld is listed on ZPMC Notification of Witness Inspection document 001819. For additional information on this inspection see the TL6027 Ultrasonic Test Report.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod phone: 134-8257-0045 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
